

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026580**Date Inspected:** 25-Oct-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** As noted below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

1. 12W 13W (Interior/Exterior)
2. 13E 14E (Interior)
3. 8E PP70.5 (Interior)
4. 13E 14E (Exterior)

1. 12W 13W (Interior/Exterior)

The QA inspector randomly observed ABF welding operator Jorge Lopez ID#6149 performing Flux Core Arc Welding with Gas (FCAW-G) in the 3G position on edge plate "F" at 12W 13W of the OBG. The QA inspector observed the QC inspector identified as John Pagliero monitoring the welding to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-3110-3. The parameters were noted as (A/250/V22). The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress and appears to be in general conformance to the contract requirements.

The QA inspector observed ABF welder Rory Hogan ID#3186 utilizing Plasma Arc Cutting to remove sections of the backing bar on the exterior of the OBG at Side Plate "E". The QA inspector made subsequent

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observations throughout the shift to monitor quality and noted that the work is in progress and appeared to be in general conformance to the contract requirements.

### 2. 13E 14E (Interior)

The QA inspector randomly observed ABF welding operator Jimmy Zhen ID#6001 performing Submerged Arc Welding (SAW) on "D/2" at 13E 14E of the OBG. The QA inspector observed the QC inspector identified as Pat Swain monitoring the welding to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-4042 B-1. The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work was completed on this date and appeared to be in general conformance to the contract requirements.

The QA inspector randomly observed ABF welding operator Wai Kit Lai ID#2953 performing Flux Core Arc Welding with Gas (FCAW-G) in the 1G position on edge plate "D/2" at 13W 14W of the OBG. The QA inspector observed the QC inspector identified as Pat Swain monitoring the welding to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-3040A-1. The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work was completed on this date and appeared to be in general conformance to the contract requirements.

### 3. 8E PP70.5 (Interior)

The QA Inspector performed a Magnetic Particle Test (MT) on a deck access hole stiffener on the interior of the OBG at 8E PP70.5. The QA Inspector utilized the MT procedure SE-MT-D1.5-CT-100 Rev. 4 to test 10% of the weld to verify the weld and testing by QC meet the requirements of the contract documents. The QA Inspector noted that the work appeared to be free of defects and was found to be acceptable and in general conformance with the contract documents. Upon completion of the MT, the QA Inspector performed Ultrasonic Testing utilizing a G. E./Krautkramer USN 60. The QA Inspector also utilized the UT Procedure identified as SE-UT-D1.5-CT-100 Rev. 4 during the examination. Upon completion of the testing, it was noted by the QA Inspector that no indications were present and the work was found to be acceptable.

### 4. 13E 14E (Exterior)

The QA inspector randomly observed ABF welding operator Jimmy Zhen ID#6001 performing Submerged Arc Welding (SAW) on A5 to A4 at 13E 14E of the OBG. The QA inspector observed the QC inspector identified as Fred Von Hoff monitoring the welding to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-4042 B-1. The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work was in progress and appeared to be in general conformance to the contract requirements.

The QA inspector randomly observed ABF welding operator Todd Jackson ID#4639 performing Submerged Arc Welding (SAW) on A2.2 to A3 at 13E 14E of the OBG. The QA inspector observed the QC inspector identified as Fred Von Hoff monitoring the welding to ensure the welding parameters were in compliance

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pertaining to ABF-WPS-D15-4042 B-1. The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work was in progress and appeared to be in general conformance to the contract requirements.

Note: The QAI reviewed the observations and inspection with QA Lead Inspector, Daniel Reyes, written in this report. No issues were noted by the QAI and the QA Lead Inspector concurs with the QA report.

### Summary of Conversations:

At the beginning the shift the QA inspector met with QC inspector John Pagliero and discussed the welders assignments and locations for the shift to include pending issues, ongoing work and required testing.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Frey,Doug	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

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